



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

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RBEA62310-01
Job Sheet 194589



Part No: RBEA62310-01

Job Qty: 12 pcs

Part Name: Top Weldment



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 5/6/19

Job Tracking No:

Due Date: 6/14/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG RBEA62310 Rev 1A IPP Rev A 18.01.17 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Large Fab - Welded Assy-1	12 pcs	6/14/19		0.00	12.00	Large Fab - 1		EL
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3		
							Large Fab - 4		
							Large Fab - 5		
							Large Fab - 6		
							Large Fab - 7		
							Large Fab - 8		
120	QC 9	12 pcs	6/14/19		0.00	0.00	QC 9 - 10		JUN 13 2019
							QC 9 - 18		
							QC 9 - 24		
							QC 9 - 43		
							QC 9 - 50		
							QC 9 - 9		
130	Powdercoat - 13 Yellow - B4B	12 pcs	6/14/19		0.00	1.20	Powdercoat - 1 - B4B		BK 19-6-06
							Powdercoat - 2 - B4B		
							Powdercoat - 3 - B4B		
							Powdercoat - 4 - B4B		
140	QC 3	12 pcs	6/14/19		0.00	0.00	QC 3 - 10		
							QC 3 - 13		
							QC 3 - 15		
							QC 3 - 17		
							QC 3 - 18		
							QC 3 - 2		
							QC 3 - 28		
							QC 3 - 3		
							QC 3 - 30		
							QC 3 - 34		
							QC 3 - 36		



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CANADA
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Container No: S189915



Part: RBEA62310-01

Job No: 194589

Serial No/Batch: S189915

Revision: 1A

Inspector:

Exp Date:

Instructions:

Date: 06/13/19

Plex 5/6/19 7:36 AM Dart.lajeunesse.marie

				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	
				QC 3 - 59	DAS
				QC 3 - 68	81
				QC 3 - 9	9-89
				QC 3 - 40	
				QC 3 - 19	
				QC 3 - 43	
				QC 3 - 24	
150	Packaging 3-1 - Stock - B4B	12 pcs	6/14/19	0.00 0.00	Packaging 3 - 1 - B4B
					Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 - B4B
					Packaging 3 - 13 - B4B
					Packaging 3 - 14 - B4B
					Packaging 3 - 15 - B4B
					Packaging 3 - 16 - B4B
					Packaging 3 - 17 - B4B
					Packaging 3 - 18 - B4B
					Packaging 3 - 19 - B4B
					Packaging 3 - 20 - B4B
					Packaging 3 - 21 - B4B
					Packaging 3 - 22 - B4B
					Packaging 3 - 23 - B4B
					Packaging 3 - 24 - B4B
					Packaging 3 - 25 - B4B
					Packaging 3 - 26 - B4B
					Packaging 3 - 27 - B4B
					Packaging 3 - 28 - B4B
					Packaging 3 - 29 - B4B
					Packaging 3 - 30 - B4B
					Packaging 3 - 31 - B4B
					Packaging 3 - 32 -

JUN 26 2019

					B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
160 QC 21 - SA	12 pcs	6/14/19	0.00	0.00	QC 21 - SA - 21	
					QC 21 - SA - 70	
					QC 21 - SA - 53	

GA 135

Part Op 110 - (Weld per dwg A/R Steel rod Batch: 138986 Weld as per DWG)
 Descriptions: 120 - (QC9- Inspect visual per QSI004- Fusion Welds)
 130 - (Powdercoat13 - Yellow #13538), Mask threads before painting
 140 - (QC3- Inspect Part Finish)
 150 - (Identify as per dwg & Stock Location: _____)
 160 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
98750A017	RH All Thread	12 pcs (1 ea)	110-Large Fab - Welded Assy-1	5161558
RBEA62310-03	Top Plate	12 pcs (1 ea)	110-Large Fab - Welded Assy-1	5105255

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Large Fab - Welded Assy-1	98750A017	12	8	0
	RBEA62310-03	12	26	0

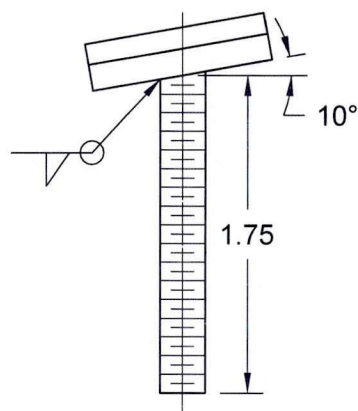
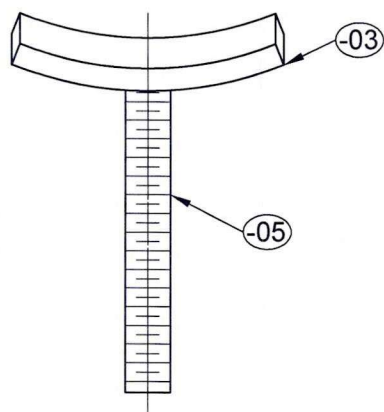
Part Specifications

Specifications could not be found.

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REVISIONS			
REV	DESCRIPTION	DATE	INITIAL
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SHOP COPY
RETURN TO
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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 194589 MJS
19-05-06

(-01)

TOP
WELDMENT

NOTES:

1. MASK THREADS BEFORE PAINTING.

RED BARN MACHINE	
TITLE AS350/355 ENGINE STRUT	
DWG NO. RBEA62310-01	REV 1A
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	DRAWN BY: PERRITT
TOLERANCES ON: DECIMALS .XXX ± .005 .XX ± .01 .X ± .1	APPROVED <i>D West</i>
METRIC REF. XXmm ± .1mm FRACTIONS ± 1/32 ANGLES ± 5°	HEAT TREAT FINISH PRIME & PAINT YELLOW
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	SPEC USED ON MODEL EUROCOPTER AS350 & AS355
SCALE NTS	DATE 3-10-10 SHEET 2 of 7

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor		
			QC / QA Coordinator		
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					